

Work Order ID 127165

Wednesday, December 10, 2014 7:13:25 AM

127165

Page 1

Item ID: D2804-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 12/10/2014 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/10/2014 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per File D2804-1-2_BLANK Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio FA103								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

(4) BC
12/14/12/09

3 (4) BC
12/14/12/09
JFC 2014-12-13

3 1 JFC 2014-12-13

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Item ID: D2804-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 12/10/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/10/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

D. P. 14/12/19

3

1

DAS
08
9-89

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

(3)

15-1-5 [Signature]

150 QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

(3)

DAS
38
9-89

JAN 05 2015

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 Required Date: 12/10/2014 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>S475</u>	0.00							
160									
Packaging	Memo	0.00				3	45		
Packaging							5		
							89		JAN 06 2015
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							15/1/6 DJ
Quality Control									

Handwritten signature/initials

Picklist Print

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Page 1

Work Order ID: 127165

127165

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 12/10/2014

Required Date: 12/10/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A00.11.06New IssueEC
IPP B06.05.30 Blanks on wtjetEC
IPP Rev:C As per Rev C 06-11-09 JLM
IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased		No			f	32.0900		3			

M6061T6B0 500X10 000

6061-T6 Bar .500 x 10.00

**

Dec 14/12/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	32.09	
M127180	23	
M130527	7	
M130860	2.09	

5

DART AEROSPACE LTD		Work Order: 127165
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

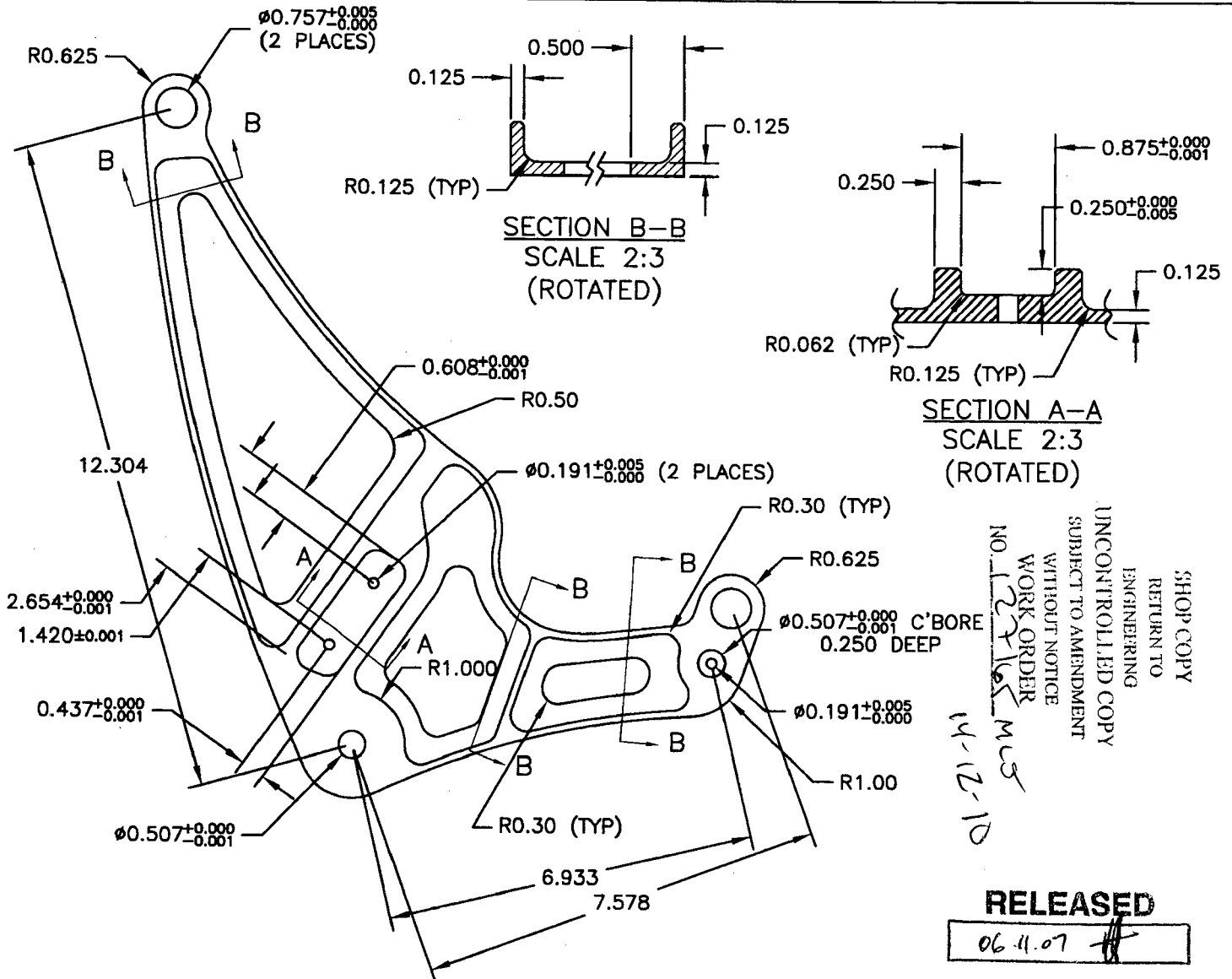
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.1265	✓		mic O-1	JTC-02
0.125	+/-0.010	0.1255	✓		mic O-1	"
R0.125	+/-0.010	R0.125	✓		Rad G	Shop
0.250	+/-0.010	0.217	✓		Caliper	JTC-01
0.250	+0.000/-0.005	0.247	✓		depth G	JTC-07
0.875	+0.000/-0.001	0.8745	✓		Cal + G block	JTC-01 + Shop
R0.062	+/-0.010	R0.062	✓		Rad G	Shop
Ø0.757	+0.005/-0.000	0.758	✓		Cal + pin	JTC-01 + Shop
R0.625	+/-0.010	R0.625	✓		Rad G	Shop
12.304	+/-0.005	12.304	✓		HL	JTC-01
Ø0.507	+0.000/-0.001	0.5065	✓		Cal + G block	JTC-01 + Shop
0.437	+0.000/-0.001	0.4365	✓		Cal. + G block	JTC-01 + Shop
0.608	+0.000/-0.001	0.6075	✓		Caliper + G block	JTC-01 + Shop
Ø0.191	+0.005/-0.000	0.192	✓		Cal pin	JTC-01
1.420	+0.001/-0.001	1.420	✓		"	JTC-01
0.250 deep	+/-0.010	0.245	✓		depth G	JTC-07
6.933	+/-0.005	6.933	✓		Caliper	JTC-01
7.578	+/-0.005	7.578	✓		"	"
0.500	+/-0.010	0.499	✓		Cal pin	JTC-01

Measured by: JTC	Audited by: B.E.	DAS 08	Prototype Approval:	N/A
Date: 2014-12-13	Date: 14/12/19	9-99	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D2804	SHEET 1 OF 2
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE			



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 127165 MCB
14-12-10

RELEASED06-11-07 *[Signature]***D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

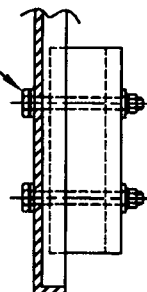
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Operator ☐ Offset/Setup ☐ Process ☐ Supplier ☐ Training ☐ Transport ☐ Unapproved ☐	14.12.18	110	1	WELD THICKNESS IS 0.109 - 0.113, IT SHOULD BE 0.125	A.P 14.12.18	THE PART IS MARGINAL UNDER BUCKLING LOADS - SCRAP / no replace -> Folio and origin been updated to prevent any more NCRs.	B.C. 14.12.18 A.P. 14/12/19 DAS 08 9-20		

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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